

# Work Order ID 117341

Monday, June 16, 2014 11:36:54 AM

**\*117341\***

Page 1

Item ID: D4881-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 206A/B AFT Leg Assembly, RH  
 Start Date: 6/16/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 6/20/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference: Part sent for marking

Approvals: Process Plan: *[Signature]* Date: 14-6-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4881	<i>Rev B per 14-573</i>								

105

0.00

**\*105\***

Purchasing

Purchasing

Memo

PULL FROM STOCK  
D4881-042 (X1) B110581

0.00

*710:24622*

PART SENT TO P&L FOR MARKING

*CL 14/06/17*

115

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*115\***

Packaging

Packaging

*120*

*022*

Memo

0.00

*Small Feb- Rework to Rev B — FF 14-06-24*

*QC5*

QC6- Inspect dimensions to drawing

0.00

125

**\*105\***

QC

Quality Control

Memo

0.00

*SP 14/6/25*

*P 14/6/18 ①*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 117341**

Monday, June 16, 2014 11:36:54 AM

**\*117341\***

Page 2

Item ID: D4881-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: 206A/B AFT Leg Assembly, RH  
Start Date: 6/16/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 6/20/14 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference: Part sent for marking

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
135		0.00							
<b>*135*</b>									
Packaging	Memo	0.00							
Packaging	REPACKAGE USING N/B								
145	QC21- Final Inspection - Work Order Release	0.00							
<b>*145*</b>									
QC	Memo	0.00							
Quality Control									

ST 125 1X SP14-6-25

ML 14-06-25

14-6-25

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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# Picklist Print

Monday, June 16, 2014 11:36:58 AM

Page 1

Work Order ID: 117341

\*117341\*

Parent Item: D4881-042

\*D4881-042\*

Parent Item Name: 206A/B AFT Leg Assembly, RH

Start Date: 6/16/14

Required Date: 6/20/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4881-042		Manufactured	No				Each	0.0000		1			
*D4881-042*										**			
206A/B AFT Leg Assembly, RH													

110581 X1 ~~H~~ 14-6-16

DAS  
10  
9-89

HL20PB-5-12 : m 128973

HL86-5 : m 128228

(2x)

FF 14-06-24

(2x)

FF 14-06-24

HySol EA934NA : M128703



19226 Airport Road  
Summerstown, ON  
K0C 2E0 Canada

Tel. 613-931-1241  
Fax 613-931-2560  
plprinting@bellnet.ca

# PACKING SLIP

**SOLD TO**

DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

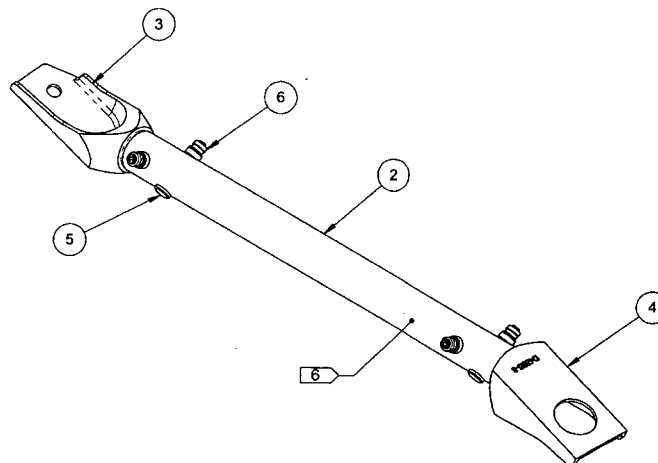
**SHIPPED TO**

DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

P.O NUMBER PO24622

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4880-042 LEG ASSEMBLY	1	ALL ITEMS HAVE BEEN LASER MARKED
D4881-041 LEG ASSEMBLY	1	
D4881-042 LEG ASSEMBLY	1	
D4882-041 LEG ASSEMBLY	2	
D4880-041 LEG ASSEMBLY	1	
D4803-1 STRUT	1	
D4871-3 END FITTING EYE	11	
D4866-2 STRUT	2	
D4882-1 STRUT	3	
D4866-1 STRUT	2	
D4928-1 STRUT	4	
D4807-041 SUPPORT ASSEMBLY	2	
D4878-1 STRUT	1	
D4867-1 STRUT	4	
D4868-1 STRUT	4	
D4884-1 END FITTING EYE	8	
D4884-3 END FITTING EYE	5	
D4801-1 STRUT	1	
D4804-1 STRUT	2	
D4806-1 CLEVIS	2	
D4806-3 STUD	8	
D4879-1 STRUT	2	

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4881-041	AFT LEG ASSEMBLY, LH
2	1	D4881-1	STRUT
3	1	D4885-1	END FITTING
4	1	D4885-3	END FITTING
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



**D4881-041 AFT LEG ASSEMBLY, LH**  
(EQUIVALENT TO BELL P/N 206-062-103-017)

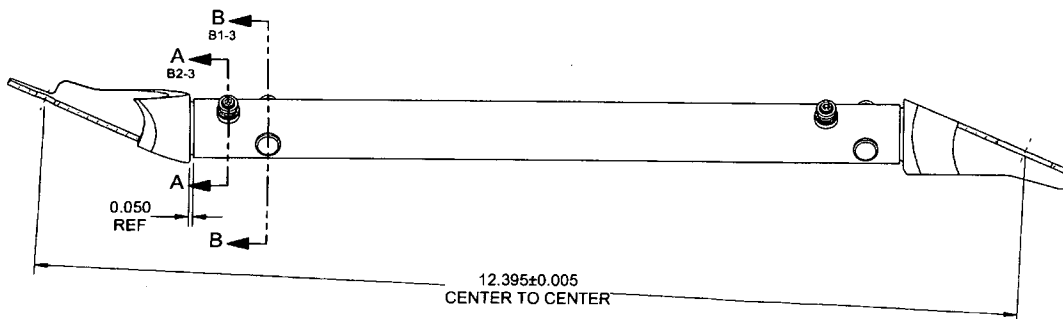
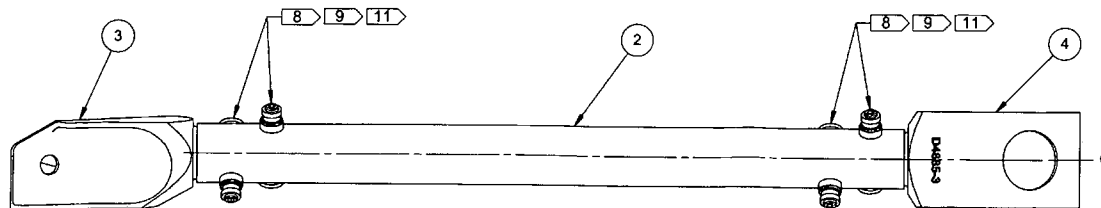
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.77 lbs
- 8) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 & D4885-3.  
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.  
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9973
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9973
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

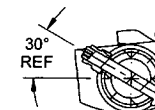
**RELEASED**  
2014-06-16  
*WJD*

B	REVISE NOTES 6, 7) & 9) (ZN A8-1, A8-3); ADDED BELL P/N; REVISE SECTIONS A-A, B-B, C-C, D-D (ZN B1-2, B2-2, B1-4, B2-4)	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	<b>D4881</b>	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
DATE	14.04.08	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

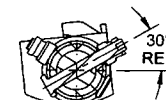
APPROVED



**D4881-041 AFT LEG ASSEMBLY, LH**  
AUXILIARY VIEW



**SECTION A-A C7-3**  
2 PL  
B



**SECTION B-B C7-3**  
2 PL  
B

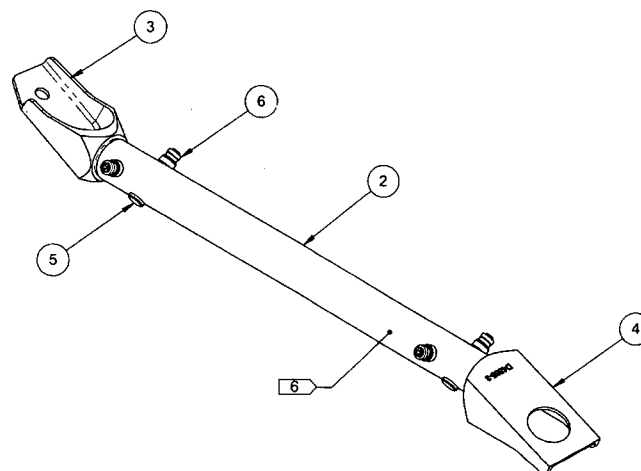
**RELEASED**  
2014-06-16

APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	<b>D4881</b>	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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ITEM	QTY. -042	P/N	DESCRIPTION
1	X	D4881-042	AFT LEG ASSEMBLY, RH
2	1	D4881-1	STRUT
3	1	D4885-2	END FITTING
4	1	D4885-3	END FITTING
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



**D4881-042 AFT LEG ASSEMBLY, RH**  
(EQUIVALENT TO BELL P/N 206-062-103-018)

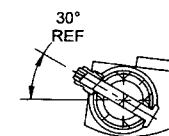
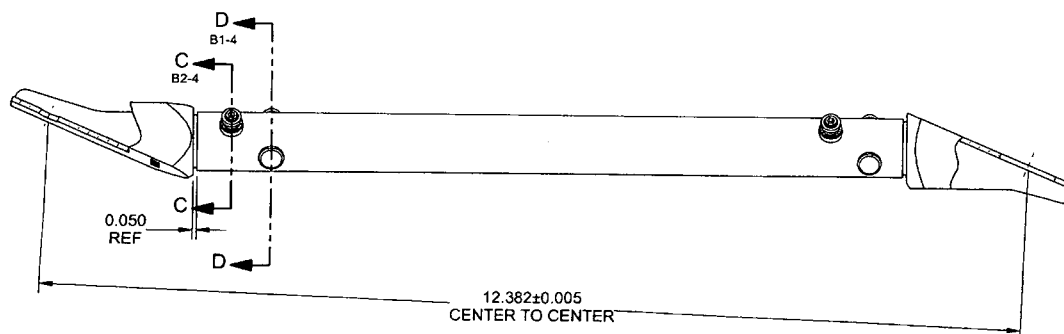
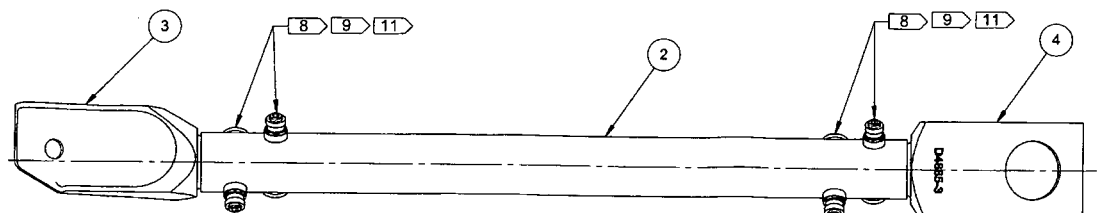
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.78 lbs
- 8) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-2 & D4885-3.  
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.  
REAM EACH HOLE USING P/N 31-219 ( $\varnothing 0.1610$ ) REAMER, USING DART TOOL SETUP DT9974
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9974
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

**RELEASED**  
2014-06-16

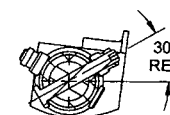
APPROVED	DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO. <b>D4881</b>	REV. B
	MFG. APPR.	JFS	SHEET 3 OF 5	
	APPROVED	HS	TITLE <b>LEG ASSEMBLY</b>	SCALE NTS
	DE APPR.	DSC	DATE <b>14.04.08</b>	

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**SECTION C-C** C7-4  
2 PL

△



**SECTION D-D** C7-4  
2 PL

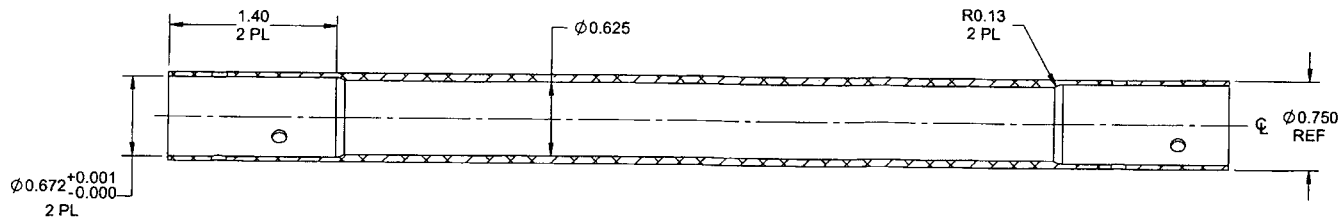
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**D4881-042 AFT LEG ASSEMBLY, RH**  
AUXILIARY VIEW

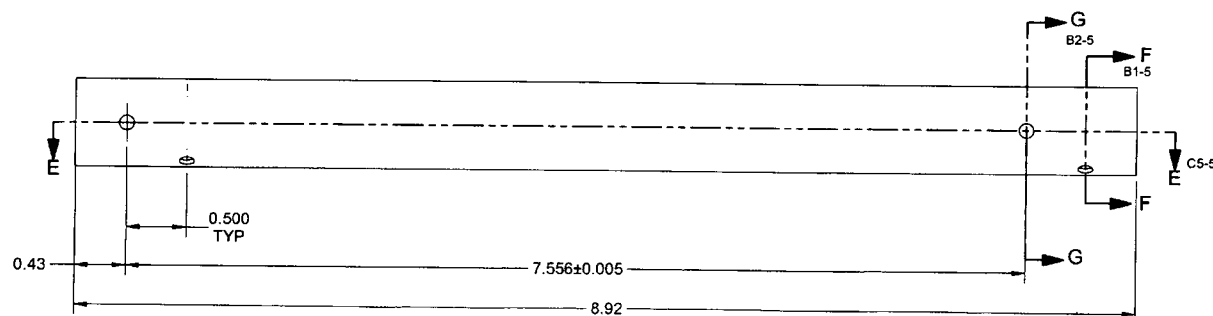
**RELEASED**  
2014-06-16  
WJ

APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	<b>D4881</b>	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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**SECTION E-E** B3-5



**SECTION F-F** C3-5  
2 PL

**SECTION G-G** C3-5  
2 PL

**D4881-1 STRUT**

**NOTES:**

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION  
PER AMS 5643/ASTM A564  
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

**RELEASED**  
2014-06-16

APPROVED	DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO. <b>D4881</b>	REV. B
	MFG. APPR.	JFS	SHEET 5 OF 5	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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